

## ABSTRACT OF DISCLOSURE

Disclosed is a free cutting steel for machine structural use having excellent chip-breakability. The steel consists essentially of, by wt.%, C: 0.05-0.8%, Si: 0.01-2.5%, Mn: 0.1-3.5%, S: 0.01-0.2%, Ca or Ca+Mg: 0.0005-0.02%, Ti: 0.002-0.010% and/or Zr: 0.002-0.025%, O: 0.0005-0.010%, and the balance of impurities and Fe. At least five MnS inclusion particles having averaged particles sizes of  $1.0\text{ }\mu\text{m}$  or more exists per  $\text{mm}^2$  per 0.01% of S-content in the steel. The steel satisfies the condition that, in the microscopic fields,  $(\text{area}[\text{ }\mu\text{m}^2]/\text{aspect ratio}) \geq 10$ , and that the the area percentage of Ca-containing sulfide inclusions containing at least 1.0wt.% of Ca is in the range of 15-40% of the area of all the sulfide inclusions.